

Date: Friday, 22/05/2009 8:58:58 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP LEG
Job Number : 48113C	
Estimate Number : 10382	
P.O. Number :	Part Number : D30655
This Issue : 22/05/2009 S.O. No. :	Drawing Number : D3065 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 48089	Material :
Written By :	Due Date : 28/05/2009 Qty: 80 Um: Each
Checked & Approved By : <u>JUD 09.05.25</u>	
Comment : Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF	
Est Rev:D Now on Water Jet 06-04-11 JLM	
Est Rev:E Now manufactured with 6061-T6 06-05-25 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 1.1338 sf(s)/Unit Total : 90.7032 sf(s)
 Material: 6061-T6 0.080" thick
 (M6061T6S.080)

Batch: 112040 1B 9-6-22

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D
 Dwg Rev: B
 Prog Rev: B

1B 9-6-22

2-Deburr if necessary

1B 9-6-22

80

P10-7

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

1B 9-6-22

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

S 09/06/23

counters

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

LMD 09/06/24

K79

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3065-5 PAR #: N/A Fault Category: Sm FAB NCR: Yes No DQA: / Date: 09.01.07
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: / Date: 09.07.15

NCR: <u>48113C</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>9/6/24</u>	<u>#20</u>	<u>Qty (1) Part Found During</u> <u>Abolix missing holes and</u> <u>a large score across the</u> <u>Part from RC w/5 stop and start</u>	<u>[Signature]</u>	<u>Scrap and destroy</u> <u>no replace Qty (1)</u>	<u>B</u> <u>9.6.24</u>	<u>[Signature]</u> <u>9.6.24</u>	<u>[Signature]</u> <u>9.5.14.2</u>	<u>S</u> <u>9.10.24</u>
	<u>Found</u> <u>on step</u> <u>#50</u>	<u>to another position: holes</u> <u>Score</u> <u>R.C. - Score is from water</u> <u>jet moving from one position to</u> <u>another.</u>	<u>[Signature]</u> <u>9.5.14.2</u>	<u> </u>	<u> </u>		<u>[Signature]</u> <u>9.5.14.2</u>	<u>S</u> <u>9.10.24</u>
		<u>- holes missing are a machine</u> <u>mal function.</u> <u>* Program is good no holes</u> <u>missing on other parts</u>	<u>[Signature]</u> <u>9.5.14.2</u>	<u> </u>	<u> </u>		<u>[Signature]</u> <u>9.5.14.2</u>	<u>S</u> <u>9.10.24</u>

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 8:58:58 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 48113C

Part Number: D30655

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



el



Comment: INSPECT CHEMICAL CONVERSION COAT

09-06-24 (79)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

SL/1012

09/06/24 (79)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



09/10/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 481130
Description: Step Leg		Part Number: D3065-5
Inspection Dwg: D3065	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
16.458	+/-0.010	16.458	X			
15.750	+/-0.005	15.750	X			
2.250	+/-0.005	2.250	X			
3.460	+/-0.005	3.463	X			
0.865	+/-0.005	.863	X			
6.020	+/-0.005	6.022	X			
1.205	+/-0.005	1.203	X			
3.484	+/-0.005	3.483	X			
0.871	+/-0.005	.873	X			
8.325	+/-0.010	8.328	*			
0.551	+/-0.010	.553	*			
0.213	+0.005/-0.000	.214	*			
Ø0.128	+0.005/-0.000	.132	*			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 9-6-22	Date: 09/06/23	Date:	N/A

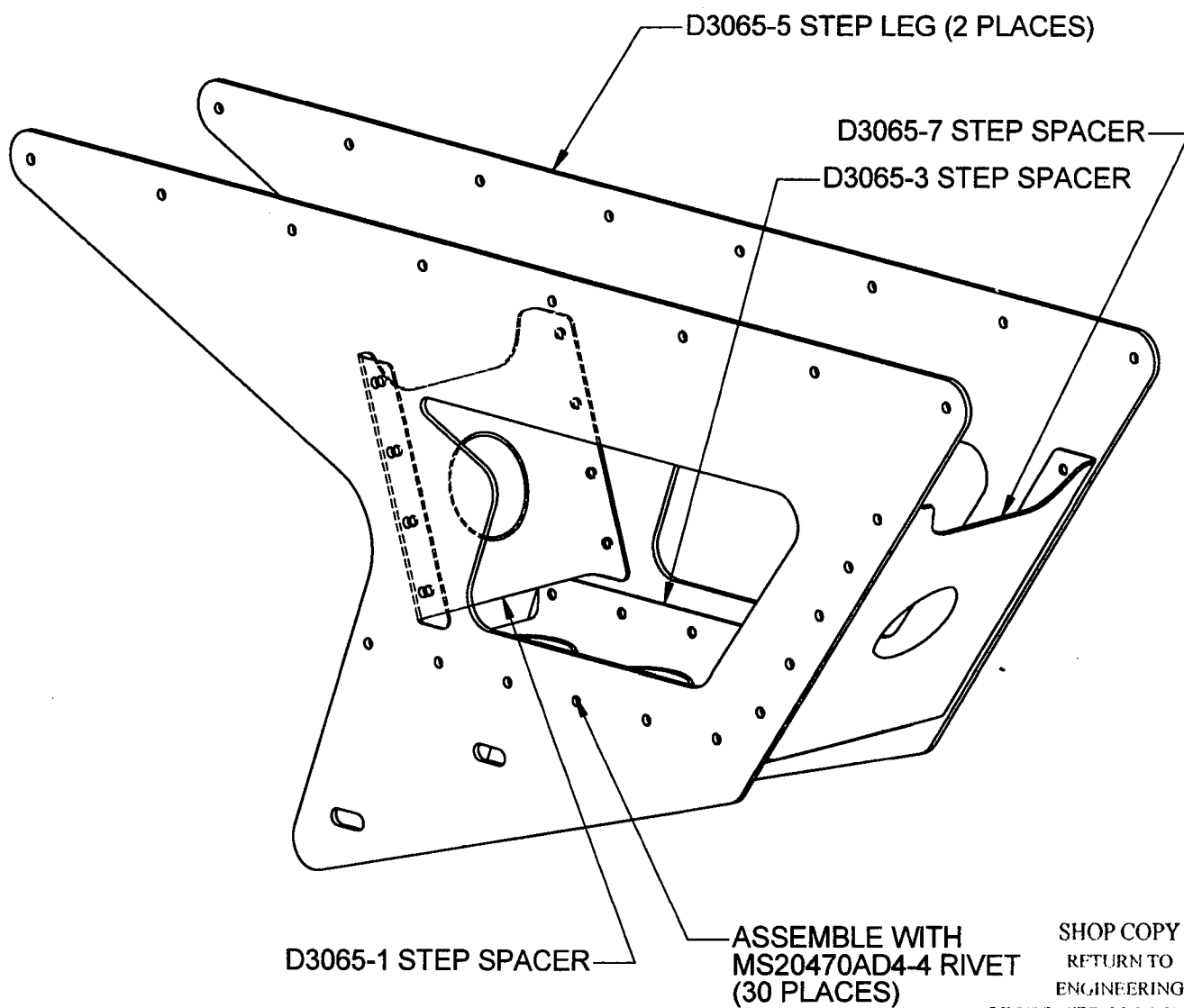
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.06.15	Added Ø0.128 dimension	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	



DESIGN <i>CP</i>	DRAWN BY <i>C.B.</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*

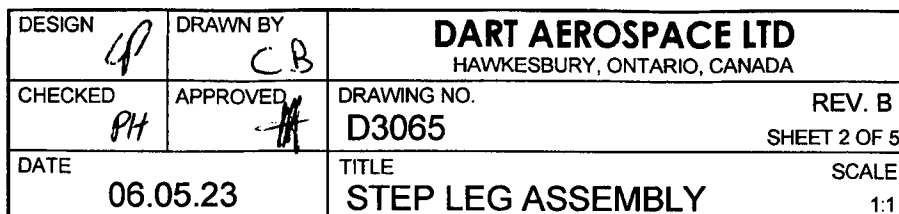


D3065-041 STEP LEG ASSEMBLY

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de de-20 #

BEND DETAIL

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WORK ORDER
NO. 48113C

D3065-1 STEP SPACER

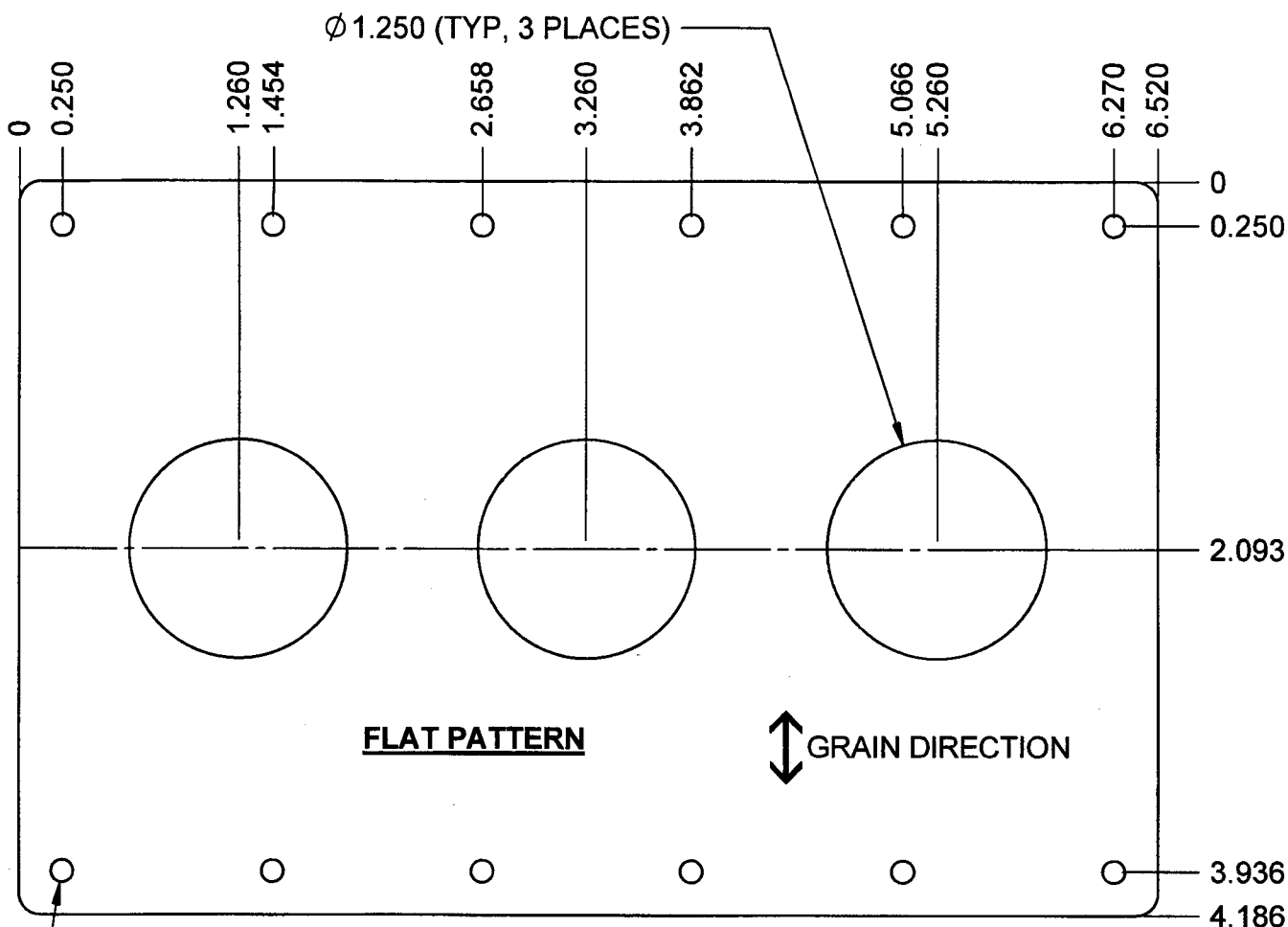
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M20)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) BREAK ALL SHARP EDGES 0.005 TO 0.010
4) PART IS SYMMETRIC ABOUT CENTERLINE
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	REV. B SHEET 3 OF 5 SCALE 1:1

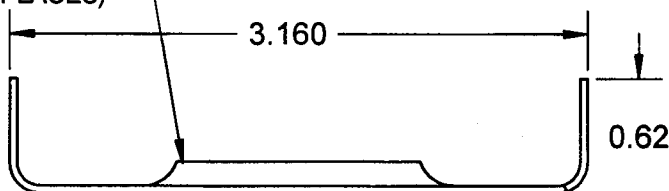


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

06.06.20



BEND DETAIL

D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER
NO. *481132*

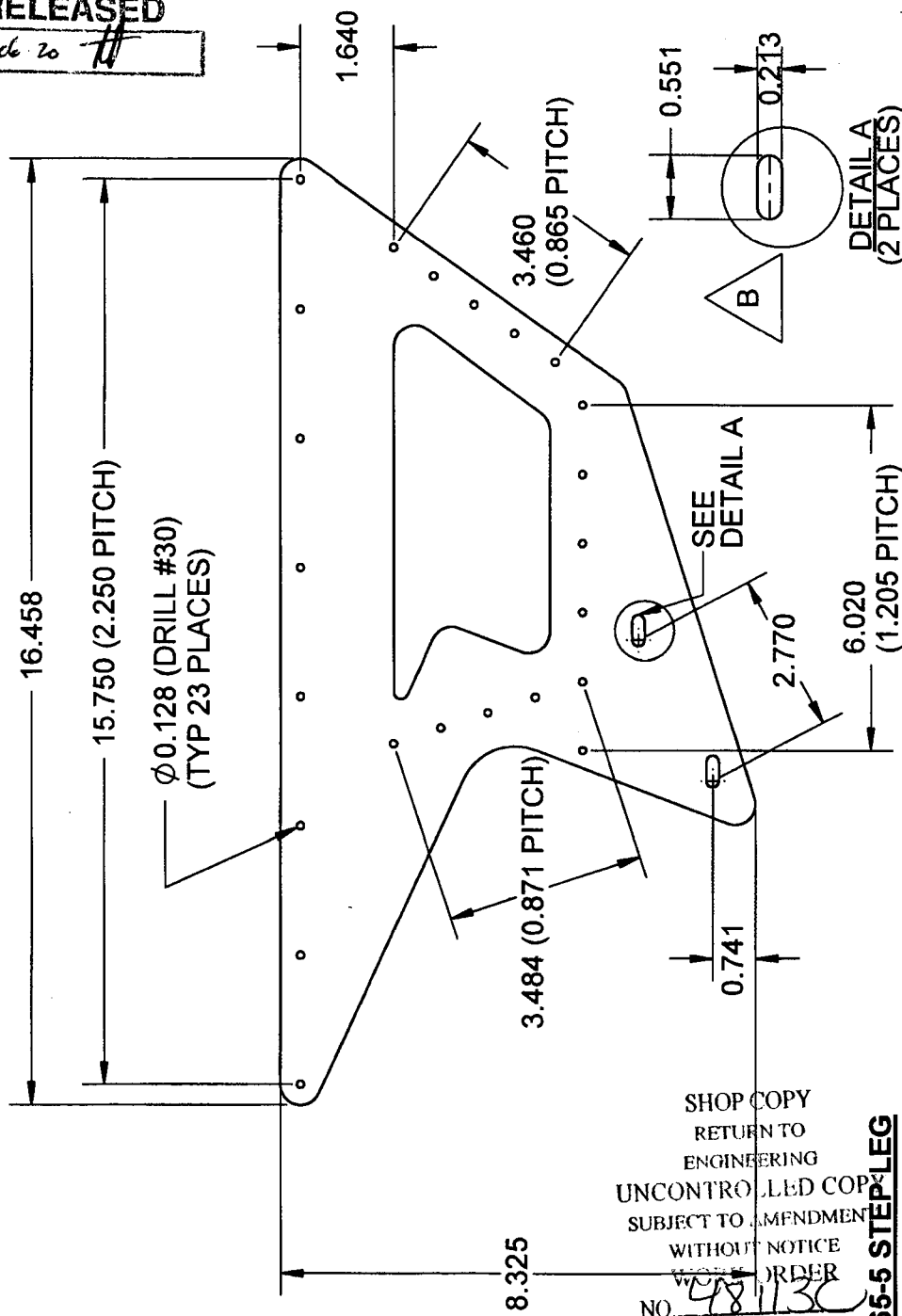
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 4 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:3

RELEASED
06.06.20



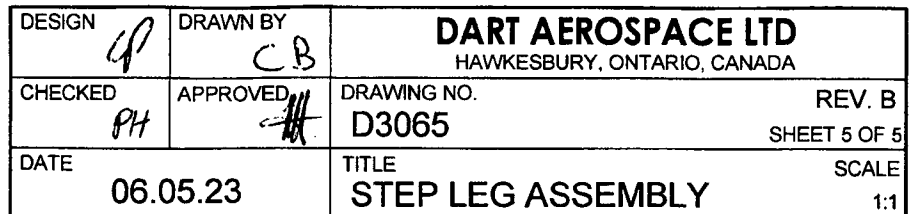
D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC M5052H32S.080)

- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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06 06 20 11

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WORK ORDER

NO. 48113C

D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S-040)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) PART IS SYMMETRIC ABOUT CENTERLINE
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

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